

**Work Order ID 63569**

Thursday, November 04, 2010 1:13:17 PM

Page 1



Item ID: D3535-15

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 11/4/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-11-04 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3535

Rev B

100



FLOW WATER JET

Waterjet

Memo

FLOW CNC Waterjet

304 . 040

I-Cut as per Dwg D3535  Dwg Rev: R  Prog Rev: R  2-  
Deburr if necessary

B 10-11-12

(13)

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

120



QC8- Inspect parts - second check

QC

Quality Control

0.00

0.00

0.00

B 10-11-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 63569**

Thursday, November 04, 2010 1:13:17 PM



Page 2

Item ID: D3535-15

Revision ID:

Item Name: Wearshoe

Start Date: 11/4/2010 Start Qty: 12.00

Required Date: 11/12/2010 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130

Operation  
Description

NC BRAKE

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Brake NC

Brake NC

Memo

0.00

SB 10/11/15

13

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

13

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Powder Coating

Memo

0.00

START TIME:

2:25

OVEN TEMPERATURE:

FINISH TIME:

2:55

13

KCL 10-11-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 63569**

Thursday, November 04, 2010 1:13:17 PM



Page 3

Item ID: D3535-15

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 11/4/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC3- Inspect Part Finish

0.00

=&gt; M 10/11/18

13 ✓

QC

Quality Control

170



Identify as per dwg &amp; Stock Location

FP-18

0.00

13 BL 10-11-18

Packaging

Packaging

180



QC21- Final Inspection - Work Order Release

0.00

10/11/18 JF

QC

Quality Control

Memo

0.00

JF  
(0-11-18)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

# Picklist Print

Thursday, November 04, 2010 1:13:21 PM

Page 1

Work Order ID: 63569



Parent Item: D3535-15



Parent Item Name: Wearable

Start Date: 11/4/2010

Required Date: 11/12/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM  
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased		No		100	sf	165.0000	1.0205	12.89053	13.2	 B10-11-12	

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT	161	
115762	10.2	
115953	150.8	115953
MAT20	4	
113062	1.398	
115440	2.602	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	63569
Description: Wearshoe	Part Number:	D3535-15
Inspector Dwg: D3535 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.888	X		V HB02	
2.000	+/-0.010	2.000	X		V	
5.650	+/-0.010	5.650	X		T HB01	
9.150	+/-0.010	9.156	O		T	
14.400	+/-0.010	14.400	X		T	
19.650	+/-0.010	19.650	X		T	
24.900	+/-0.010	24.906	O		T	
30.150	+/-0.010	30.150	O		T	
33.650	+/-0.010	33.650	O		T	
35.650	+/-0.010	35.656	X		T	
39.150	+/-0.010	39.150	O		T	
Ø0.188	+0.005/-0.001	1.93	X		V	
24.00	+/-0.030	24.00	X		T	
16.00	+/-0.030	16.00	X		T	
8.00	+/-0.030	8.00	X		T	
5.00	+/-0.030	5.00	X		T	
0.300	+/-0.010	0.305	X		T	
0.300	+/-0.010	0.306	X		T	
0.038	+/-0.010	0.038	X		V	

Measured by:	BS	Audited by:	AC	Prototype Approval:	N/A
Date:	10-11-12	Date:	10/10/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	EE

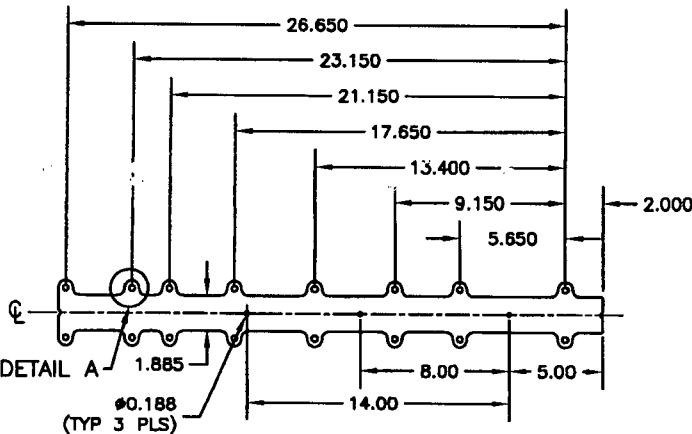
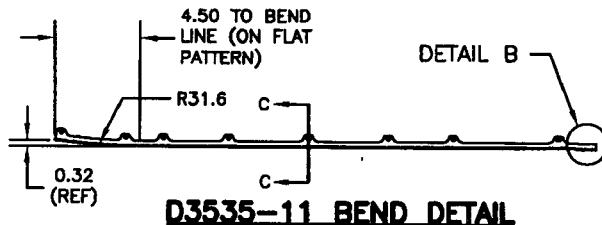
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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

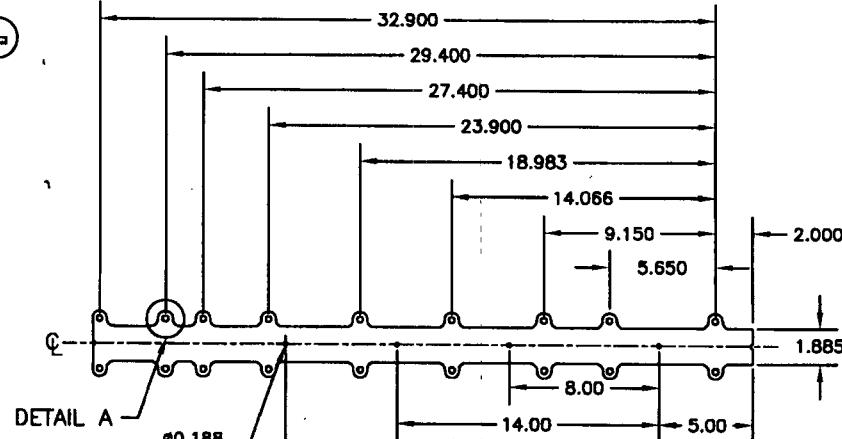
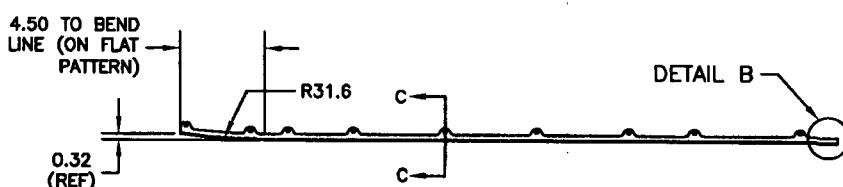
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART****D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *63569*  
*BD 10-11-09*

RELEASED  
57-04-24 *[Signature]*

**D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CB	<i>[Signature]</i>	
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3535
DATE		TITLE
07.04.17		WEARSHOE
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC
		SHEET 1 OF 7
		SCALE 1:10
		REV. B

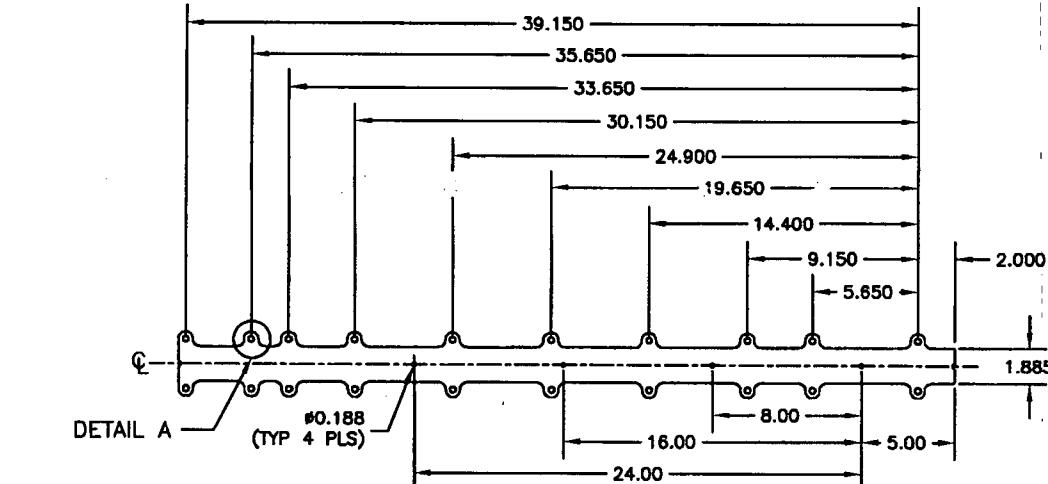
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

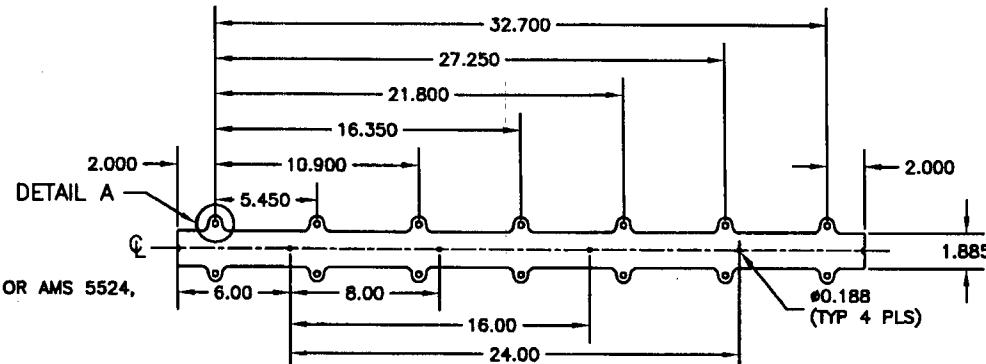
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**RELEASER  
07.04.24**D3535-15 BEND DETAIL**

w/o 43569

**D3535-21 BEND DETAIL****NOTES**

- MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- PART IS SYMMETRICAL ABOUT  $\frac{Q}{2}$
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- BREAK ALL SHARP EDGES TO 0.010 MAX
- IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. B
C.B	<i>PH</i>	DRAWING NO. D3535	
CHECKED	<i>PH</i>	DATE 07.04.17	
APPROVED	<i>PH</i>	TITLE WEARSHOE	SCALE 1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

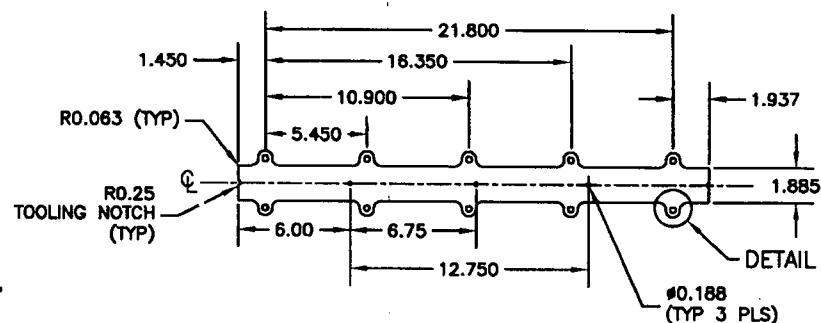
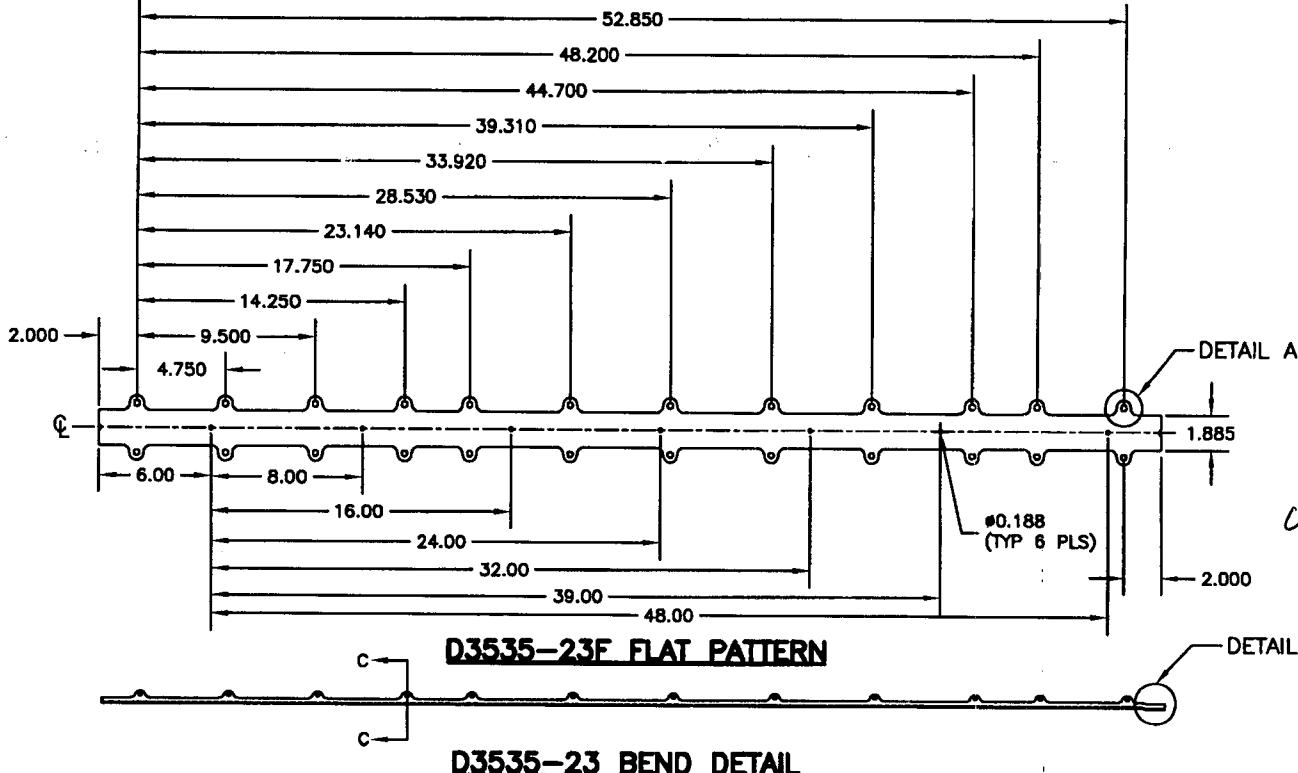
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <b>C.B</b>	DRAWN BY <b>PH</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA
CHECKED <b>H</b>	APPROVED <b>H</b>	DRAWING NO. <b>D3535</b>
DATE <b>07.04.17</b>	TIME <b>11:00</b>	SCALE <b>1:10</b>

RELEASED  
07.04.24 - *H**w/c 63569*

**NOTES**

- MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- PART IS SYMMETRICAL ABOUT C
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES
- BREAK ALL SHARP EDGES TO 0.010 MAX
- IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

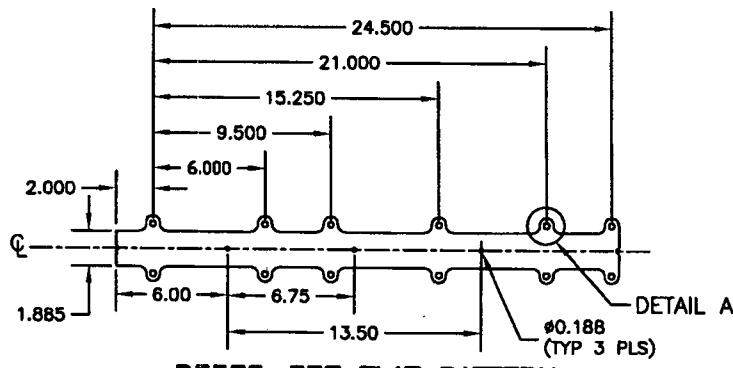
NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C B	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
✓	✓	D3535
DATE		TITLE
07.04.17		WEARSHOE
		REV. B
		SHEET 4 OF 7
		SCALE
		1:10

RELEASED  
07.04.24

w/043569



**D3535-33F FLAT PATTERN**



**D3535-33 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

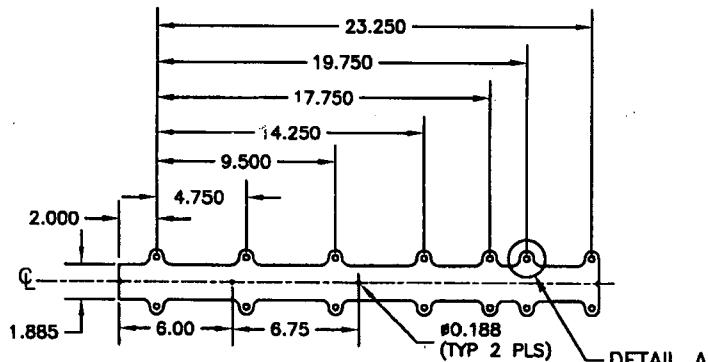
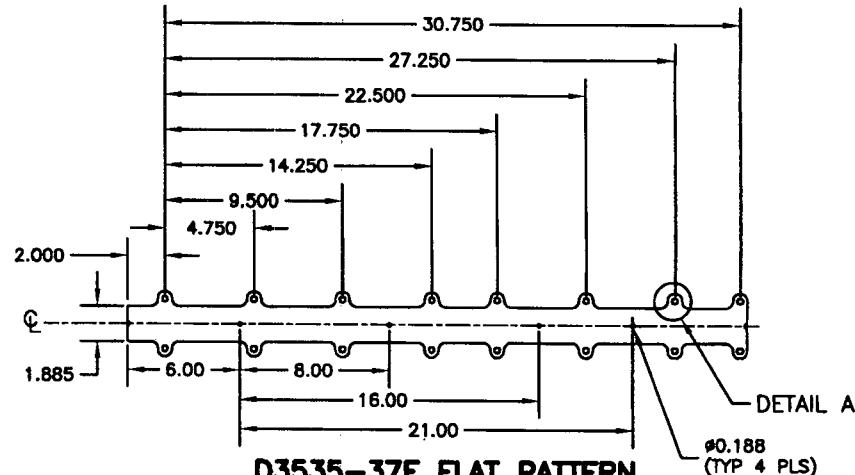
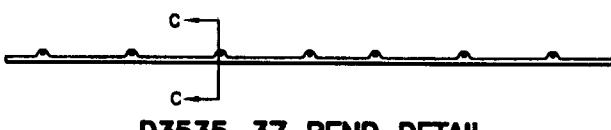
**DART**

DESIGN <b>C8</b>	DRAWN BY <b>PH</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <b>MM</b>	APPROVED <b>MM</b>	DRAWING NO. <b>D3535</b>
DATE <b>07.04.17</b>		TITLE <b>WEARSHOE</b>

REV. B  
SHEET 5 OF 7  
SCALE  
1:10

RELEASED  
07.04.24

w043569

**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL****D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

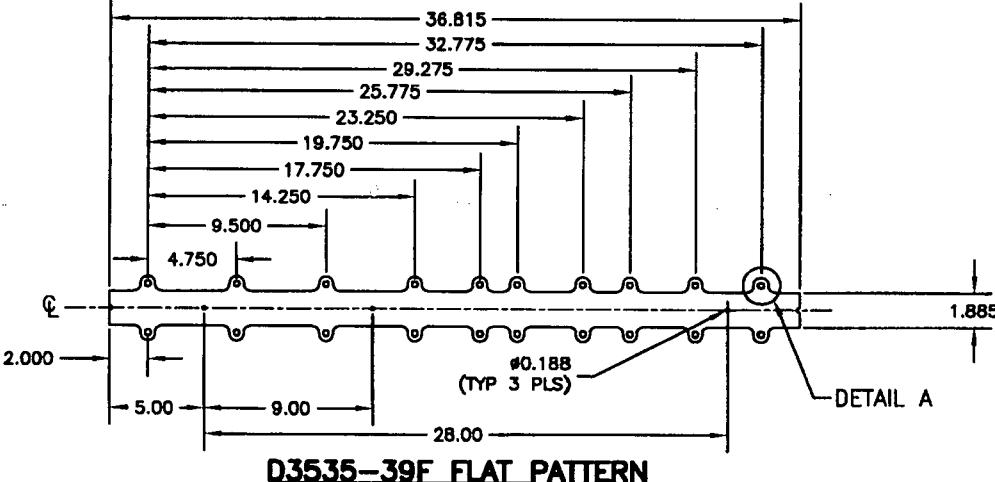
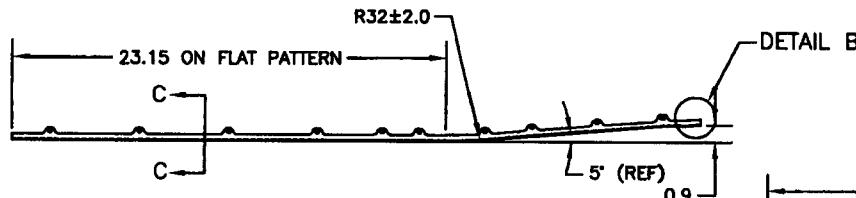
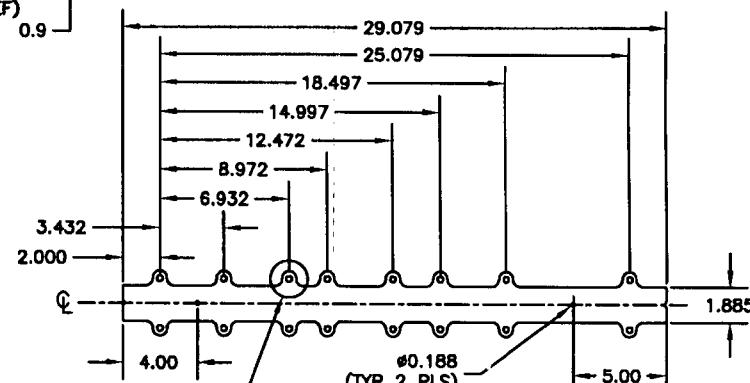
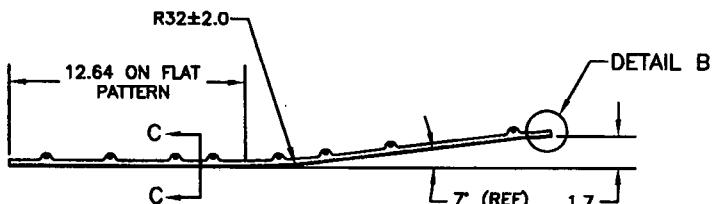
NOTE: Date & initial all entries

**DART**

DESIGN <b>C.B</b>	DRAWN BY <b>PW</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA
CHECKED <b>#</b>	APPROVED <b>#</b>	DRAWING NO. <b>D3535</b>
DATE <b>07.04.17</b>		TITLE <b>WEARSHOE</b>
		REV. B SHEET 6 OF 7 SCALE <b>1:10</b>

RELEASED  
07.04.24

w/o 43569

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\frac{Q}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

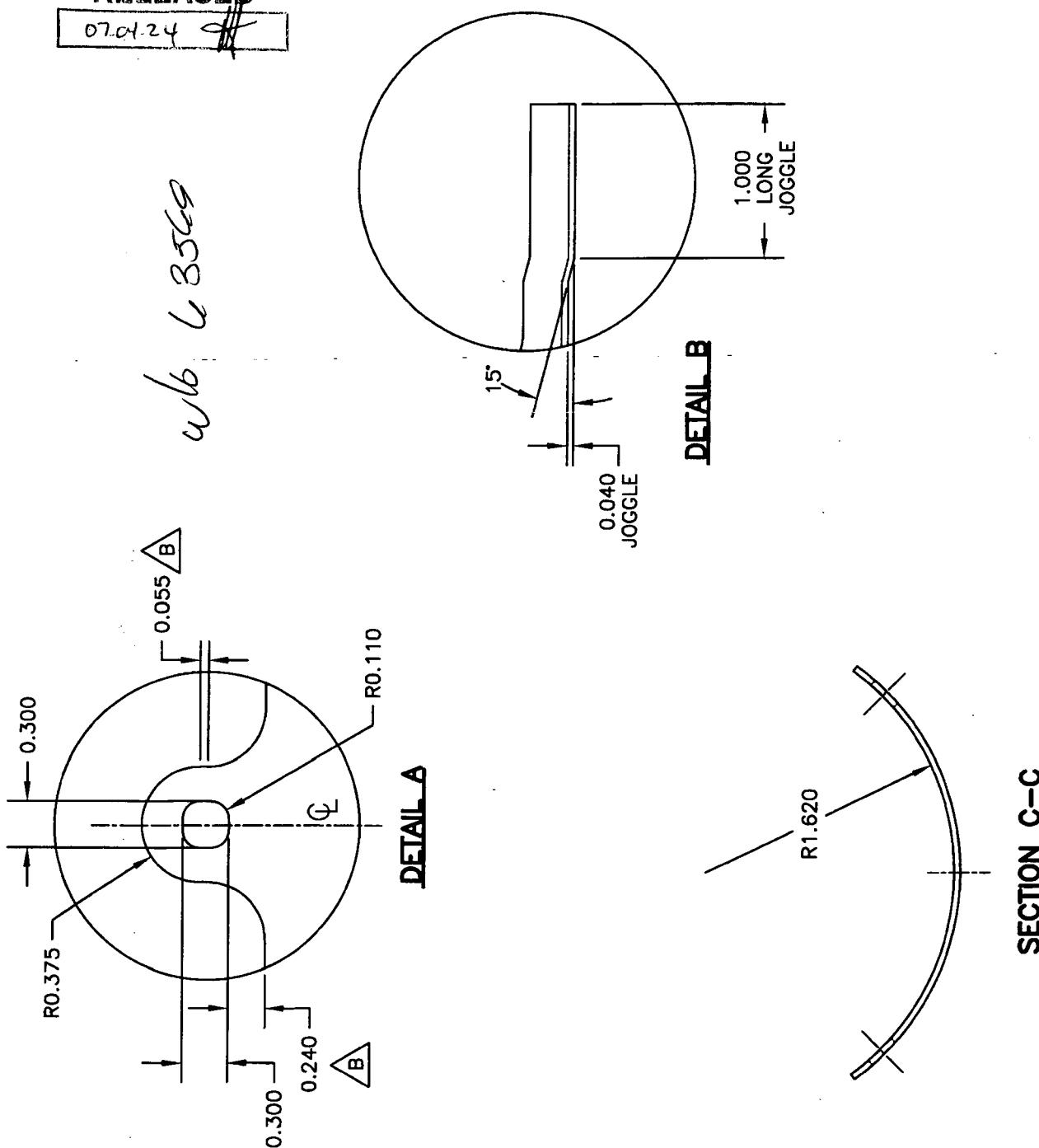
NOTE: Date & initial all entries

**DART**

DESIGN <i>CB</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

RELEASED

07.04.24



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries